



Dart Aerospace Ltd.
1270 Aberdeen St
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Tel (613) 632-5200
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D4434-1
Job Sheet 186684



Part No: D4434-1

Job Qty: 2 ea

Part Name: Bracket



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/20/18

Job Tracking No:

Due Date: 11/30/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: D4434 REV C IPP REV:A 13.04.01 AS PER D4434 REV.C DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	2 pcs		11/30/18	0.00	0.23	Waterjet - Flow		218/11/20
120	QC	2 pcs		11/30/18	0.00	0.00	QC8		38
130	Brake NC	2 pcs		11/30/18	0.04	0.23	Brake NC 2		DAS 30
150	QC	2 pcs		11/30/18	0.00	0.00	QC5		38
160	HandFinish	2 pcs		11/30/18	0.00	0.23	HandFinish1		D.R. 19/01/2019
170	QC	2 pcs		11/30/18	0.00	0.00	QC7-3		JAN 21 2019 68
180	Packaging	2 pcs		11/30/18	0.00	0.00	Packaging3-2	St 613	JAN 23 2019
190	QC21-SA	2 Ea		11/30/18	0.00	0.00	QC21		21 JAN 24 2019

Part Op 100 - 1-Cut D4434-1 as per Dwg Dwg Rev: C Prog Rev: C 2-Deburr if necessary
Descriptions: 130 - 1-C'sink as per dwg.

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6S.040	6061-T6 .040 Sheet	3.1320 sf (1.566 ea)	100-Waterjet - Flow - 1	5018292

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M6061T6S.040	3	225	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Bracket	0.098Inches + 0.004 - 0.001	0.102 0.097	0,099	Diameter
2	Bracket	0.177Inches + 0.005 - 0.001	0.182 0.176	0,180	Diameter
3	Bracket	0.468Inches ± 0.010	0.478 0.458	0,470	
4	Bracket	0.234Inches ± 0.010	0.244 0.224	0,235	
5	Bracket	0.670Inches ± 0.030	0.700 0.640	0,669	
6	Bracket	3.880Inches ± 0.030	3.910	3,884	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION		AGAINST DEPARTMENT/PROCESS			
	Rework ☐	Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	
	Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	
	Use-as-is ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	
	Suspected Unapproved ☐	Large Fab ☐	Composite ☐			

Date : _____ Step #: _____ QTY Effective _____

Description Work Order Deviation

Description Work Order Deviation	Completed By _____
	and / Supervisor Approval Verification _____
	Coordinator Approval _____

DART AEROSPACE
 Container No: S129434
 Part: D4434-1
 Job No: 186684
 Serial No/Batch: S129434
 Revision: C
 Inspector: _____
 Exp Date: _____
 Instructions: Various STC's
 Date: 11/20/18
 DART Aerospace Ltd.
 1270 Aberdeen Street
 Markham, ON L3R 9K7
 CANADA
 TEL: 1 813 632-5200
 Email: sales@dartaero.com
 www.dartaerospace.com

Root Cause			FAULT CATEGORY		
Environment ☐	No Re-verification ☐	Pressure/Force ☐	Power ☐	ed Wrong ☐	
Design ☐	Operator ☐	Bending ☐	Force ☐	Dimensions ☐	
Doc/Data ☐	Offset/Setup ☐	Centre Not Co ☐	Grain ☐	Over/Under tolerance ☐	
Equip/Tooling ☐	Supplier ☐	Cracks ☐	weld ☐	Part Incorrect ☐	
Handling/Pre ☐	Training ☐	Crimp/Kink/Rip ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	
Material ☐	Use for Testing ☐	Cuffs ☐	Out of Sequence ☐	Part Moved ☐	
Internal Transport ☐	Poor Information ☐	Crushing ☐	Off-set ☐	Drawing ☐	
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Mislabeled ☐	Finish ☐	
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Fit/Function ☐	Misread ☐	
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Misaligned/off center ☐	Turning Sequence ☐	
Past Expiry Date ☐	Manufacturing Process ☐				
Misidentified ☐	Past Due ☐	OTHER : _____			

			3.850	
7	Bracket	10.260Inches $\pm$ 0.030	10.290 10.230	10,260
8	Bracket	2.527Inches $\pm$ 0.010	2.537 2.517	2,530
9	Bracket	10.390Inches $\pm$ 0.030	10.420 10.360	10,40
10	Bracket	2.020Inches $\pm$ 0.030	2.050 1.990	2,025
11	Bracket	2.470Inches $\pm$ 0.030	2.500 2.440	2,472
12	Bracket	2.720Inches $\pm$ 0.030	2.750 2.690	2,725
13	Bracket	4.270Inches $\pm$ 0.030	4.300 4.240	4,274
14	Bracket	22.200Inches $\pm$ 0.030	22.230 22.170	22,200

Plex 11/20/18 10:09 AM Dart.lajeunesse.marie

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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								